

5/41

DART AEROSPACE LTD	Work Order:	24082
Description: Long Step Assembly – High Skid, RH	Part Number:	D350-591-312
		704A 41 640 011
Dwg: D3272 Rev. A	Qty:	10
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HA	05.08.23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001	HA	05.10.12	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3272 using cutting table Setup DT 8185-2A. Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion 32456.3	LE	06.3.23	10
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	LE	06.3.23	10
5	GA	Deburr	LE	06.3.23	10
6	QC5	Inspect work to Step 5	LE	06.03.23	10
7	WA	Bevel end for welding FWD ONLY	LE	06.3.23	10
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324205 324097 2 D3219-1 Support 324097 A/R Aluminum Rod M18338	LE	06.03.24	10
9	GA	Grind End Plate flush	LE		
10	QC9 & 5	Inspect weld and work to Step 9	LE	06.03.27	10
11	FP	Chemical conversion coat as per QSI 005 4.1	LE	06/03/29	10
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 324408 2 D3066-1 Spacer 324408 16 MS20600AD4W4 Rivet M18438 M17185	LE	06.03.30	10
13	QC5	Inspect work to step 12	BE	06-03-30	10
14	WA	Bevel Aft end for welding	LE	06.03.30	10
15	WA	Inspect for foreign object as per QSI 024	LE	06.03.30	10
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate 324205 A/R Aluminum Rod M18338	LE	06.03.30	10
		Identify as D3272-042			

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																																																																				
17	GA	Grind End Plate flush	JE	06-04-03	10																																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 108.93" & 3.375" as per Dwg D3272	NO	06-04-03	10																																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	DL	06/04/05	10																																																																				
20	FP	Wing Walk as per Dwg D3272 and QSI 005 4.4	DL	06/04/05	10																																																																				
21	QC3	Inspect Powder Coat and Wing Walk	FC	06/04/05	10																																																																				
22	KP	<p>Pick: Packing Kit (Note: D3272-042 is on BOM as material listed in Step 3)</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2230-3</td><td>Mounting Lug</td><td>(8x) 826203</td></tr><tr><td>2</td><td>D2618</td><td>Bushing</td><td>824090 (2200)</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>824091</td></tr><tr><td>2</td><td>D3235-1</td><td>Mounting Lug</td><td>826011</td></tr><tr><td>1</td><td>D3272-042</td><td>Step Assembly</td><td>824095</td></tr><tr><td>1</td><td>D3278-041</td><td>Support Assembly</td><td>824082</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt (5) M19551</td><td>824096</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>M17944 (15)</td></tr><tr><td>2</td><td>AN5-36A</td><td>Bolt</td><td>M19099</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>M16114</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M19521</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M19085</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M18254</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M18917</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M19099</td></tr><tr><td></td><td></td><td></td><td>M19073</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2230-3	Mounting Lug	(8x) 826203	2	D2618	Bushing	824090 (2200)	2	D2856-400-720	Abrasion Strip	824091	2	D3235-1	Mounting Lug	826011	1	D3272-042	Step Assembly	824095	1	D3278-041	Support Assembly	824082	2	AN3-35A	Bolt (5) M19551	824096	8	AN4-13A	Bolt	M17944 (15)	2	AN5-36A	Bolt	M19099	4	AN960JD10	Washer	M16114	16	AN960JD416	Washer	M19521	4	AN960JD516	Washer	M19085	2	MS21042L3	Nut (or -3)	M18254	8	MS21042L4	Nut (or -4)	M18917	2	MS21042L5	Nut (or -5)	M19099				M19073			
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23	QC4	Inspect Kit 100% for Completeness on the W/O	AS	06/04/06	10																																																																				
24	PK	Package for shipping as per PPP D350-591-312	Rev B	06/04/06	10																																																																				
25	AC	Cost / part		06/04/11	10																																																																				
26	DC	Close W/O Inspect Level 21		06/04/11	10																																																																				

Rev	Date	Change	Revised By	Approved
A	04.03.22	New issue	KJ/RF	

RELEASED
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/04/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024082
Project Name : D350-591-312
Project For : WK541
Work Order Type : Main
Main WO Number :
House Part Number : *D350-591-312
Description : Heli-Access-Step, RH Hi
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-16-05
Est Finish Date : 10-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00